

split Blue Feb. 15

Work Order ID 79235 -2

\*79235\*

Page 1

January-24-12 9:56:39 AM

Item ID: D3414-041 ~~28~~ 28  
Revision ID:  
Item Name: Lug Assembly  
Start Date: 24/01/2012 Start Qty: 40.00 \*40\*  
Required Date: 10/02/2012 Req'd Qty: 40.00 \*40\*  
Reference:  
Accept \*N900040100\*  
Setup Start \*NS1\*  
Stop \*NS2\*  
Cust Item ID:  
Customer:

Approvals: Process Plan: M.C.S. Date: 12/01/24 Tooling: Date:  
QC: Date: SPC (Y/N): Date:  
Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev C								
100		0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3414-1								
302-100	Dwg Rev: C								
	Prog Rev: C								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

B.12-1-26

44

B.12-1-26

# Work Order ID 79235

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Item ID: D3414-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Lug Assembly

Stop **\*NS2\***

Start Date: 24/01/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

140

0.00

**\*140\***

Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414  
A/R S.S. welding rod Batch: **116577**

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**\*79235\***

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**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 24/01/2012      **Start Qty:** 40.00

**\*40\***

**Cust Item ID:**

**Required Date:** 10/02/2012      **Req'd Qty:** 40.00

**\*40\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

175

0.00

**\*175\***

## SprayPaint

## Memo

0.00

## Spray Painting

PRIME B 117319  
 DELFLEET BLUE B 118395  
 CLEAR DELFLEET B 118093

# Work Order ID 79235

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Item ID: D3414-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Lug Assembly

Stop **\*NS2\***

Start Date: 24/01/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	QC14- Inspect Spray Paint	0.00							
<b>*185*</b>									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location <b>220</b>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

12-03-13 (28)

12/13 (200) P

12/3/14 J

12-03-13

# Picklist Print

January-24-12 9:56:42 AM

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Work Order ID: 79235

**\*79235\***

Parent Item: D3414-041

**\*D3414-041\***

Parent Item Name: Lug Assembly

Start Date: 24/01/2012

Required Date: 10/02/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	131.3300	0.155	6.2			
<b>*M304S12GA*</b>									<b>**</b>				
304/316 0.100" Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT019		131.33							
				113062		117.1							
				113077		14.23							
D3414-3		Manufactured	No			140	Each	0.0000	1	40			
<b>*D3414-3*</b>									<b>**</b>				
Lug													

B12-1-28

131.33

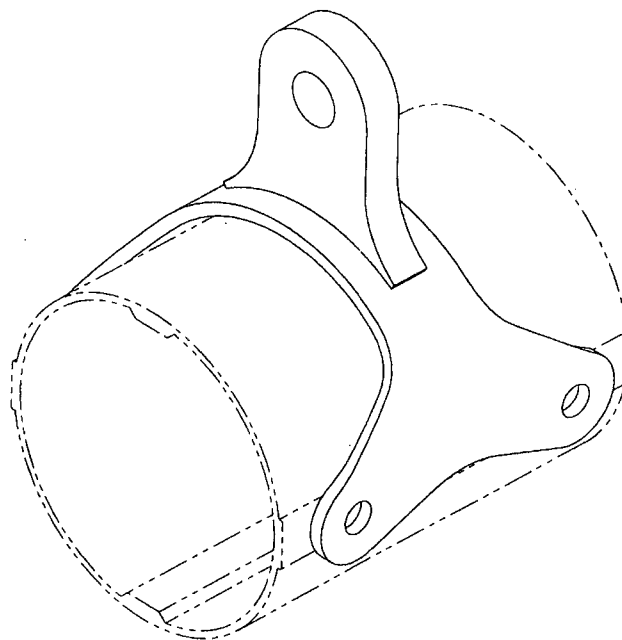
44

10.02.15

B78923 → 40x



ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



**D3414-041 LUG ASSEMBLY**

**NOTES:**

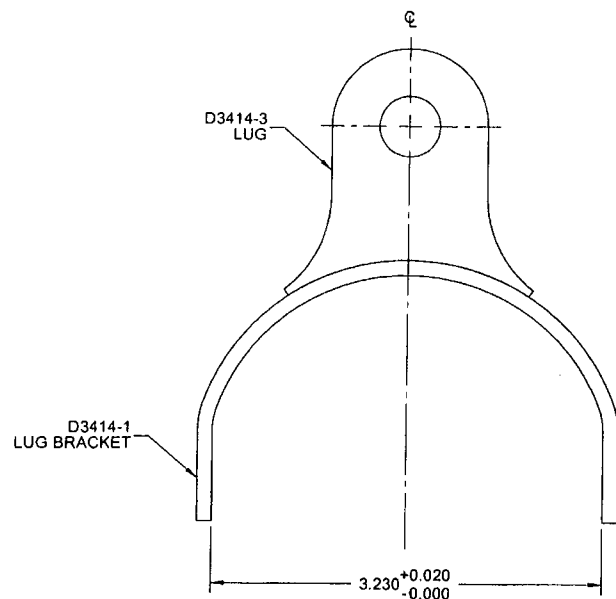
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

79235 M.L.J  
12/01/24

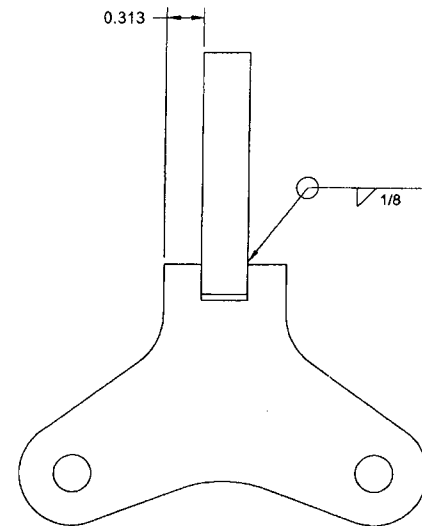
**RELEASED**  
8/16/25/14

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

79235



**D3414-041 LUG ASSEMBLY**

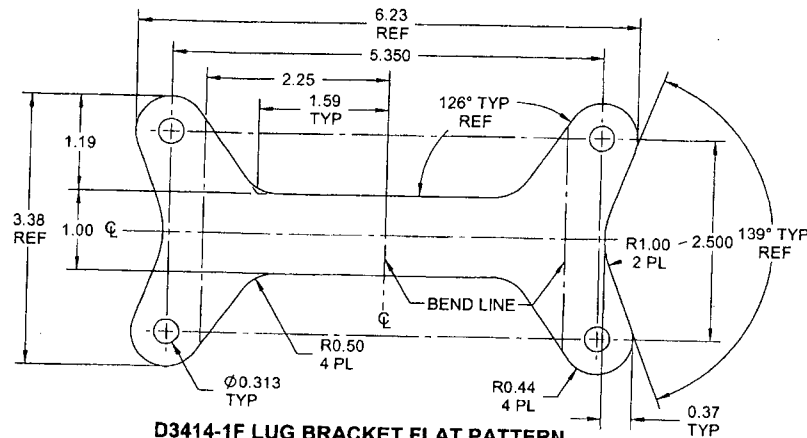


**RELEASED**

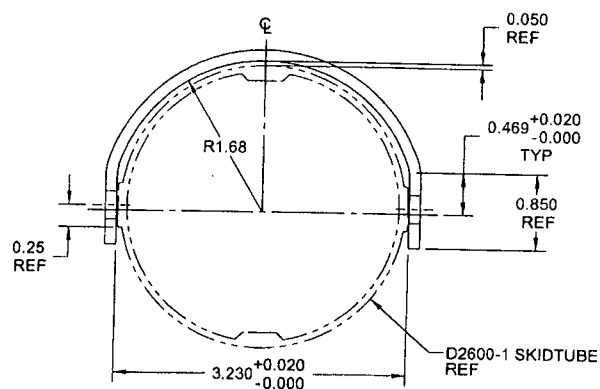
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DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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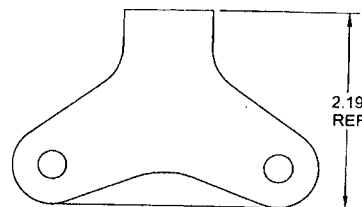
79235



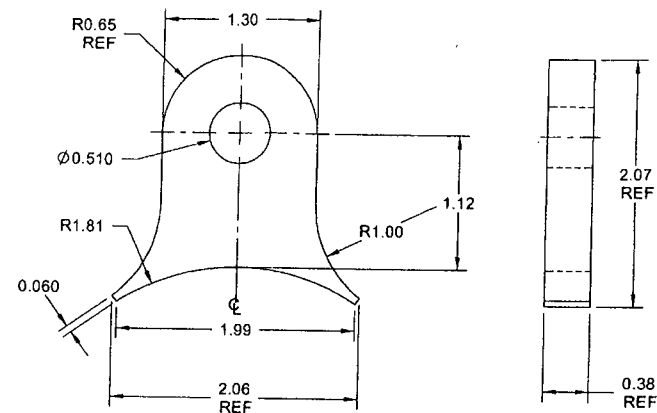
**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**



SIDE VIEW FOR REF ONLY



**D3414-3 LUG**

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX  
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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